

Work Order ID 125096

Tuesday, October 07, 2014 10:35:15 AM

125096

Page 1

Item ID: D350-567-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Exterior SS Window

Start Date: 9/26/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: MLJ Date: 14-10-07 Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-567	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPD350-567-113								
110	Packaging	0.00							
110									
Packaging	Memo	0.00							
Packaging	Pick Packing Kit								
	ENSURE DT 8439 TEMPLATE IS INCLUDED								
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 15-01-08

DAS
46
9-89

JAN 09 2015

1x

JAN 07 2015

DAS
66
9-89

1x

DAS
46
9-89

JAN 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 125096

Tuesday, October 07, 2014 10:35:15 AM

125096

Page 2

Item ID: D350-567-113

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Exterior SS Window

Start Date: 9/26/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Packaging Memo Identify and pack for shipping as per PPPD350-567-113 Location: _____ PPP Rev: _____	0.00 0.00				DAS 65 9-89	JAN 09 2015		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MLJ 15-01-12			MLF 15-01-09

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, October 07, 2014 10:35:14 AM

Page 1

Work Order ID: 125096

125096

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior SS Window

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 04-08-24 New Issue JLM
 IPP Rev:B 08-10-07 as per revD DD verified by: IPP REV:C
 13.10.15 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8439 *DT8439* TEMPLATE	DAS 46	Manufactured	No				Each	0.0000	**				DAS 06 9-89
D2463		Manufactured	No			110	f	334.0137	7.166	7.543158			
D2463 1/2" Seal (\$Per Foot)	DAS 46								**				DAS 06 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST409		334.013684							
				110718		25.063684							
				115701		308.95							
D3290-041		Manufactured	No			110	Each	2.0000	**				DAS 06 9-89
D3290-041 Replacement Exterior Window For -111	DAS 46												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST434		2							
				114042		1							
				120157		1							
2600-6		Purchased	No			110	Each	266.0000	**				
2600-6 Camlock Stud	DAS 46												
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST389		166							
				M128398		166							
				ST396		100							
				M129790		100							

JAN 08 2015

DAS
06
9-89

DQA: _____ Date: _____



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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 2

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Work Order ID: 125096

125096

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior SS Window

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

2600-LW

Purchased

No

110

Each

282.0000

12

12

2600-LW
Washer, Camlock Retaining

DAS
46
C-29

**

DAS
46
9-89

Location

Loc Qty

Loc Code

ST342

100

m128429

100

ST396

182

m128818

175

m129198

2

m129732

5

12

mf

212-12

Purchased

No

110

Each

308.0000

12

12

212-12
Receptacles

DAS
46
C-29

**

DAS
46
9-89

Location

Loc Qty

Loc Code

ST396

208

M128818

175

M129198

33

ST568

100

M129706

100

12

mf

AN526C832R9

Purchased

No

110

Each

545.0000

21

21

AN526C832R9
Screw

DAS
46
C-29

**

DAS
46
JAN 08 2015
9-89

Location

Loc Qty

Loc Code

ST328

545

M128429

145

M129391

400

21

mf

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Design									
Doc/Data									
Equip/Tooling									
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Training									
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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 125096

125096

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior SS Window

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

110

Each

1,649.000

42

42

DAS
66
9-89

NAS1149DN832J

Washer

DAS
46
9-89

Location

Loc Qty

Loc Code

ST277

1649

M128948

147

124555

145

M126319

11

M127255

36

M128429

883

M129499

135

M129541

292

42 MF

MS21042L08

Purchased

No

110

Each

2,818.000

21

21

DAS
66
9-89

MS21042L08

Nut

DAS
46
9-89

Location

Loc Qty

Loc Code

ST306

2818

123900

1

125445

268

m127304

99

m127410

175

m128401

1500

m128429

69

m129541

106

m130325

600

21 MF

MS20426AD3-5

Purchased

No

110

Each

6,508.000

24

24

DAS
66
9-89

MS20426AD3-5

Rivet

DAS
46
9-89

Location

Loc Qty

Loc Code

ST314

6508

4444

1710

4533

4798

24 MF

JAN 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Tuesday, October 07, 2014 10:35:14 AM

Work Order ID: 125096

125096

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior SS Window

Start Date: 9/26/14

Required Date: 10/06/14

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

110

sf

2,044.000

18

18

FG-778150-550-ROL

7781 9oz Glass 50x125yd

DAS

46

9-89

Location

Loc Qty

Loc Code

CA

1945

M127570

574

M127701

1371

ST418

99

M127701

99

**

JAN 08 2015

DAS

06

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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